

Work Order ID 70716

Monday, June 13, 2011 2:26:40 PM



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Item ID: D412-698-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, LH

Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

Sulor/09

CL 11/06/14
HJ for BG 11-7-20 (2)

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/7/21 (2) f

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sulor/09

(2)

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Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-011 Location: <u>62</u> <u>RECUB</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/11

32

11/9/13

ME
11-09-12

Picklist Print

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Work Order ID: 70716

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH



Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from
Step 1,3 KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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S ₇ D3121-141 Bracket Assembly		Manufactured	No			100	Each	6.0000	3	6			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST235A	6	
68242	6	

S ₇ D3121-143 Bracket Assembly		Manufactured	No			110	Each	7.0000	1	2			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST235A	7	
61406	1	
68265	6	

S ₇ D3183-043 Bracket Assembly		Manufactured	No			110	Each	2.0000	1	2			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST236	2	
66829	2	

S ₇ D3137-043 Bracket Assembly		Manufactured	No			110	Each	5.0000	1	2			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST235B	5	
69047	5	

B70979 2x

Picklist Print

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Work Order ID: 70716

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH



Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

12.0000



Bracket

9 18 (4x) (14x) SP
B69757 B70977

Location

Loc Qty

Loc Code

ST236A

12

61484

2

68241

10

Manufactured No

110

Each

9.0000

D3202-1



Cover

1 2 SP 11/7/21 (2)

Location

Loc Qty

Loc Code

ST241A

9

66252

1

68240

8

2

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Shop Packet Print

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6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01